*Quality Control

Work Orde Tuesday, August			05444	*,	105	444	*						Page 1
Revision ID:	D2067 Connector		Section 1.	Accept		*N9	ററ	<u>040</u>	100)* s	Setup Start	1.7	S1* S2*
Start Date: Required Date: Reference:	8/6/2013 9/13/2013	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*				Item l omer:	ID:					
Approvals:	Process Pla	n: (X	Date: 13/08/0	GTooling:			D:	ate:	_		Run Start	!/	R1*
	QC:		Date:	SPC (Y/				ate:			Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set U		Too	ol ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr				.,							
D2067	В	j											
*100 *100* Purchasing Purchasing		Supplier: Ar	t Number: FT319 ens Controls f conformity is required	0.00						_Co	<u> 13/08</u>	3 <u>/06</u>	50
110 *110* Packaging Packaging		Receive & Inspect for Da	•	0.00 0.00 ned							/3/u	/5/	(50)
*120 *120 *20		QC6- Inspect dimensions	s to drawing	0.00	DAS 27 9-89	21				50			

										DQA:	Date	e:		
NCR: Ye	es / No				WORK ORDER NON	l-COI	VFORM	MANCE / UP	DATE	QA Closed:	Date	2:		
Work Order	7 :				DISPOSITION	:	AGAINST DEPARTMENT/PROCESS							
Part No	0				Rework Scrap Use-as-is Work Order Update	f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root				Descr	ription of work order update	: 1	nitial	Ac	tion	Sign &				
Cause	Date	Step	Qty	·	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector		
oc/Data quip/Tooling Operator Material etup Other Process supplier Training											,			
•		•				FAUI	LT CATE	GORY						
Landin	g Gear			_	General				_	_	_	_		
	Bending Centre Not Concentric to O/S Cracks Broken/Damage Burrs Cuffs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion BOM/Route Bom/Route Broken/Damage Burrs Contamination Countersink Cut Too Short Drill Holes Drawing						Instruct Mainte Mislabe Misread Offset Out of	ion Incomplete ions Incomplete/ enance eled d Calibration	'Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Turning Sequence Finish						Out of !	Sequence						

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

£ '4

Work Orde Tuesday, August			*105444*										Page 2		
Revision ID: Item Name:	D2067 Connector 8/6/2013 9/13/2013	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*	c	900 ust Item I ustomer:		100	Sto				S1* S2*			
Approvals:		an:	Date:	Tooling:			ate:	-	R		Start Stop		R1*		
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab		Operation Description Small Fab Memo 1- Enlarge hace 2- Assemble	Date:	SPC (Y/N): Set Up/ Run Hours 0.00 0.00		Da	Tool #	Plan Code	Accept Qty	Reje Qty	ect l	*N Reject Number	R2* Insp. Stamp		
140 *140* QC* Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00 Sh	7				SO						
150 *150* Packaging		Identify as per dwg & Sto	ock Location: STOO4	0.00					_50>		AS 28	13-11	-26		

Packaging

													DQA:	Dat	te:	
NCR: Y	es /	No					WORK ORDER NON-C	CON	VFORI	MANCE / UPI	DATE		QA Closed:	Dat	te:	
Work Orde	r·						DISPOSITION	-			AGAINST (DEI	PARTMENT	PROCESS		
Part N	o					Rework Scrap Use-as-is Work Order Update			Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root Cause		Date	Step	Qty	Desc	-	tion of work order update r Non-conformance	1	nitial ief Eng		ion ription		Sign & Date	Verification	n	QC Inspector
quip/Tooling perator Material etup other crocess upplier fraining																
	•						F	AUL	T CATE	GORY						
Landin	ng Ge	 ar					General		_					. <u> </u>		
	Bending Centre Not Concentric to O/S Cracks Bro Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Bend Bend Bend Bend Bend Bend Bend Ben				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	-	Instruct Mainte Mislabe Misread Offset Out of	ion Incomplete ions Incomplete/lenance eled d	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	T	Turning Sequence Finish						1	Out of Sequence							

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Quality Control

Work Orde						Page 3			
Item ID: Revision ID: Item Name:	D2067 Connector			Accept	*N9000	ገ4በ1በበ*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	8/6/2013 9/13/2013	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Item ID Customer:) :			
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Dat		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160*)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Ac Code Qt		y I	Reject Insp. Number Stamp
QC QC		Memo		0.00		1/			

NCR: Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	

		,				WORK ONDER NOW				QA Closed:	Dat	e:	
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
						Rework		Skid-tube	Crosstube		Water Jet	Engineering	
Part N	No.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	•					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	No.					Work Order Update		Large Fab	Composite	te Supplier			
Root					Descri	ption of work order update	Initial	Ad	ction	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator							ļ						
Material													
Setup										į			
Other			ļ										
Process													
Supplier													
Training													
Unapproved				L		_			-				
						F.	AULT CATI	GORY					
Landi	ng (Gear				General				_		·	
		Bending				Bend	Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld	
		Crushed/	Crimped			Burrs	Instruc	tions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination	Maint	enance		Part Moved	_		
	Heat Treat Countersink				Countersink	Mislab	eled		Positioned \	Vrong _			
E .	Inspection Strip in Tube Cut Too Short				Cut Too Short	Misrea	d		Power Loss/	'Surge [Other		
	Ripples in Bend Drill Holes				Offset								
1		Torque W	/aves in E	xtrusio	n 🗌	Drawing	Out of	Calibration					
		Turning S	equence			Finish	Out of	Sequence					
	Wave/Twist in Tube Folio				Folio-	Outsid	e Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

105444

Parent Item:

D2067

Parent Item Name:

Connector

Start Date: 8/6/2013

Required Date: 9/13/2013

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:E 02.09.09 Re-format; Added AN960JD10KJ REV.B DD VERF:EC

IPP REV:F 11.01.19 AS PER DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location		Route Seq ID	Unit of Measure	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
AN960JD10 WASHER	NAS1149D0363J	Purchased MI24392	60)	4		130	Each	0.0000	1	50	13 11	25	36 9-89
FT319 Connector	70	Purchased				110	Each	0.0000	1	50	boler		/ 13/1
MS21042L3		Purchased	No			130	Each	7,513.0000	1	50	13/	11/2	DAS 36
				Location		Loc Oty	Ī	oc Code			1	1	9-89
•				FP001		3							
• •					122141	3							'
				GA		18							
					122452	18				<u> </u>			
				ST314		956							'
					111668	1							
					117885	32							
					119017	55							
					119075	138							
e de la companya de l					123265	43							
•					M126036	687							
				ST506		1536			-				
					123900	912							
Secondary Commencer Commen					124291	624							
				ST510a		5000							
劉 - [1]		•			M126275	1000							
					M126333	4000				<i>D</i>			

					•						DQA	: Dat	te:
NCR: Ye	es / N)			WORK	ORDER NON-	CON	FORN	AANCE / UPI	DATE	QA Closed	: Dat	te:
Work Orde	r:				D	SPOSITION			-	AGAINST D	EPARTMEN	T/PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			_	Water Jet od. Eng. Coor. ore/Packaging Supplier	Quality Other
Root Cause	Date	Step	Qty	Descr	ription of wor	k order update		nitial ef Eng		tion ription	Sign & Date	Verification	n QC Inspector
quip/Tooling Operator Material etup Other Process upplier Fraining													
<u> </u>			<u> </u>			F	AUL	T CATE	GORY				
Landin	g Gear				G	eneral							
	g Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes			Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Undo Part Incom Part Lost/I Part Move Positioned Power Los	Missing d Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ŀ	<u>}</u> ````						Offset Out of Calibration					· · · · · · · · · · · · · · · · · · ·	
ŀ		Torque Waves in Extrusion Drawing Turning Sequence Finish						Out of Calibration Out of Sequence					

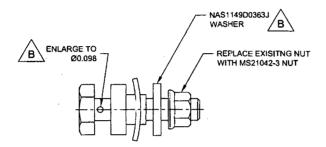
Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

SPECIFICATION CONTROL DRAWING



D2067 CONNECTOR

C213/08/04 W10: \$05444

NOTES:

1) MATERIAL: PURCHASED FROM ARENS.
SUPPLIER P/N: FT319

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE
7) WEIGHT: LESS THAN 0.01 lbs

В			AS1149D0363J WASHER & NOTE E TO Ø0.098. REF. NCR#10-383	MB	11.01.17
Α	NEW IS	SUE		RF	99.04.30
REV.			DESCRIPTION	BY	DATE
DESIGN		7	DART AEROSP	ACE	LTD
DRAWN		AI	HAWKESBURY, ONTAR		
CHECK	ED	-	DRAWING NO.		REV. B
MFG. AF	PR.	Δ.	D2067	5	SHEET 1 OF 1
APPRO	VED	-#-	TITLE		SCALE
DE APP	R.	#	CONNECTOR		NTS
DATE	11.01	1.17	COPYRIGHT © 1999 BY DART / THIS DOCUMENT IS PRINCE AND CONFIDENTIAL AND IS SUPPLI NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUN	ALD ON THE EXPRE	SS CONDITION THAT IT IS .



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

THE CONTRACT OF THE PROPERTY O PURCHASE ORDER

Purchase Order ID PO20804

Purchase Order Date 8/6/2013 PO Print Date 8/7/2013

Page Number 1 of 1

Order From:

ELLIOTT MANUFACTURING 23297 NETWORK PLACE CHICAGO, IL 60673-1232 US

VU-ELL001

DART AEROSPACE LTD Ship To:

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA



Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: Ship Acct: 607 772 0404

FedEx Pl collect

Buyer

Chantal Lavoie

Customer POID Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FOB Origin

REVISED

Line Nbr	Reference Vendor Part Number Line Comments	Description/ Mfg ID	Req Date/ CD Taxable Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
٠	FT319 AS PER DWG D2067 REV. I	Connector B B105444	11/29/2013 Yes 11/29/2013	50.00 Each	\$16.67	\$833.50

Line Total:

\$833.50

PO Total:

\$833.50

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer. No substitution or deviation without consent.

Certificate of Conformity or Material Certification required (YES

PST# 6122-5207

8/7/2013

Change Nbr:

2 .

Change Date:



607-772-0404 Fax: 607-772-0431

Packing List

Order Date: 08/07/2013 Printed Date: 11/18/2013

Page: 1

Ship To:

DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 CANADA SO Shipment



Sales Order 197011-13322



stomer ID Purchase Order	Terms	Ship Via	F.O.B.	Sales Person	Ship From	Source
AR130 PO20804	NET 30 DAYS	FEDX-GRD-COLLECT	origin	OF	ONSITE	
Order Qty Shipped Qt Backorder Qt	y U.O.M. Item Nu y Description	umber			Req. Date	Item Status
50/ 50/ 5					11/27/2013	Sale
	Elliott Item: DART P/N FT319	FT319			·	
	LEVEL 1 C OF C PS-004 REF QUOTE Q-0	0028491 ATTACHED		•		
						,



Elliott Manufacturing PO Box 773 Binghamton, NY 13902-0773 Tel: (607) 772-0404

Website: www.elliottmfg.com

an **Act**uant Company

CONFORMANCE CERTIFICATE FOR MATERIAL SHIPPED

Dated 11/18/2013

Elliott Manufacturing hereby certifies that all materials and processes used in the manufacture of parts called for on Purchase Order Number PO20804 received from DART AEROSPACE LTD conform to manufacturing specifications indicated in drawings or specifications as called for on said purchase order. Process certifications, chemical and physical test reports, as required by drawing, specification and/or other applicable documentation are on file and may be inspected by the buyer and/or government representative upon request.

Description		Cus	tomer Part Numbe	<u>r</u>	Quantity		
REV H FITTING	. 15 %		FT319	and the second property of		50 EA	

ELLIOTT MANUFACTURING

BY:

TITLE: Tech

